

Date: Tuesday, 01/05/2007 2:24:01 PM  
User: Linka Lacelle

## Process Sheet

SPW 17-05-16

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUIDE ASSEMBLY  
 Job Number : 31870-2  
 Estimate Number : 12709  
 P.O. Number : N/A  
 This Issue : 01/05/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LARGE FAB ASSY  
 Previous Run : 31870  
 Part Number : D3572041  
 Drawing Number : D3572 REV.B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 13/05/2007 Qty: 60 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-02-07 JLM  
 est rev B revB dwg EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D35723 GUIDE



Comment: Qty.: 4.0000 Each(s)/Unit Total: 240.0000 Each(s)

GUIDE

Batch: 31912

2.0 D35727 CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)

CAP

Batch: 31914

3.0 D35725 BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

BRACKET

Batch: 31913

4.0 M6061T6T1000W188 6061T6 TUBE 1.00 X .188W



Comment: Qty.: 2.3405 f(s)/Unit Total: 140.4270 f(s)

6061-T6 Round Tube 1.00"x 0.188 wall

Batch: 319101 319102

M18147

30.426



X11

SUBSTITUTE 1" OD 6061-T6 ROD

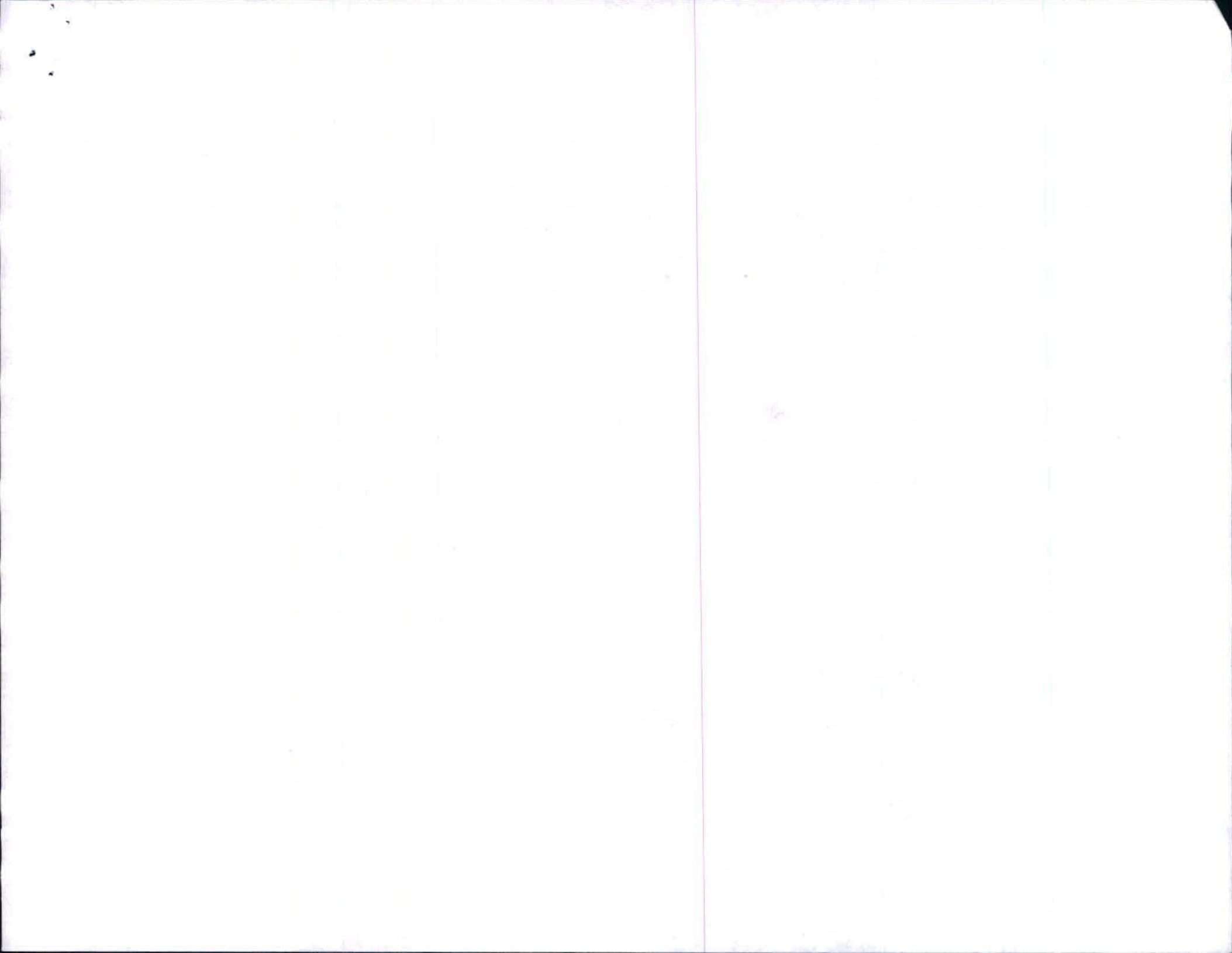
07/05/11

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
 1-Cut Tube D3572-1 as per Dwg D3572

07/05/11/16



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 31870

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Weld D3572-3 guides ,D3572-7 caps and D3572-5 bracket as per Dwg D3572  
A/R AL ROD Batch: 1102756

3-Grind welds for end caps.

07-05-15 (14) P10 →

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-05-15 (14)



Comment: INSPECT WORK TO CURRENT STEP

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/15 (14)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/05/15 (14)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07/05/15 (14X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-05-22 (2) P10 →

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/23 7/5/23 (2) (2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



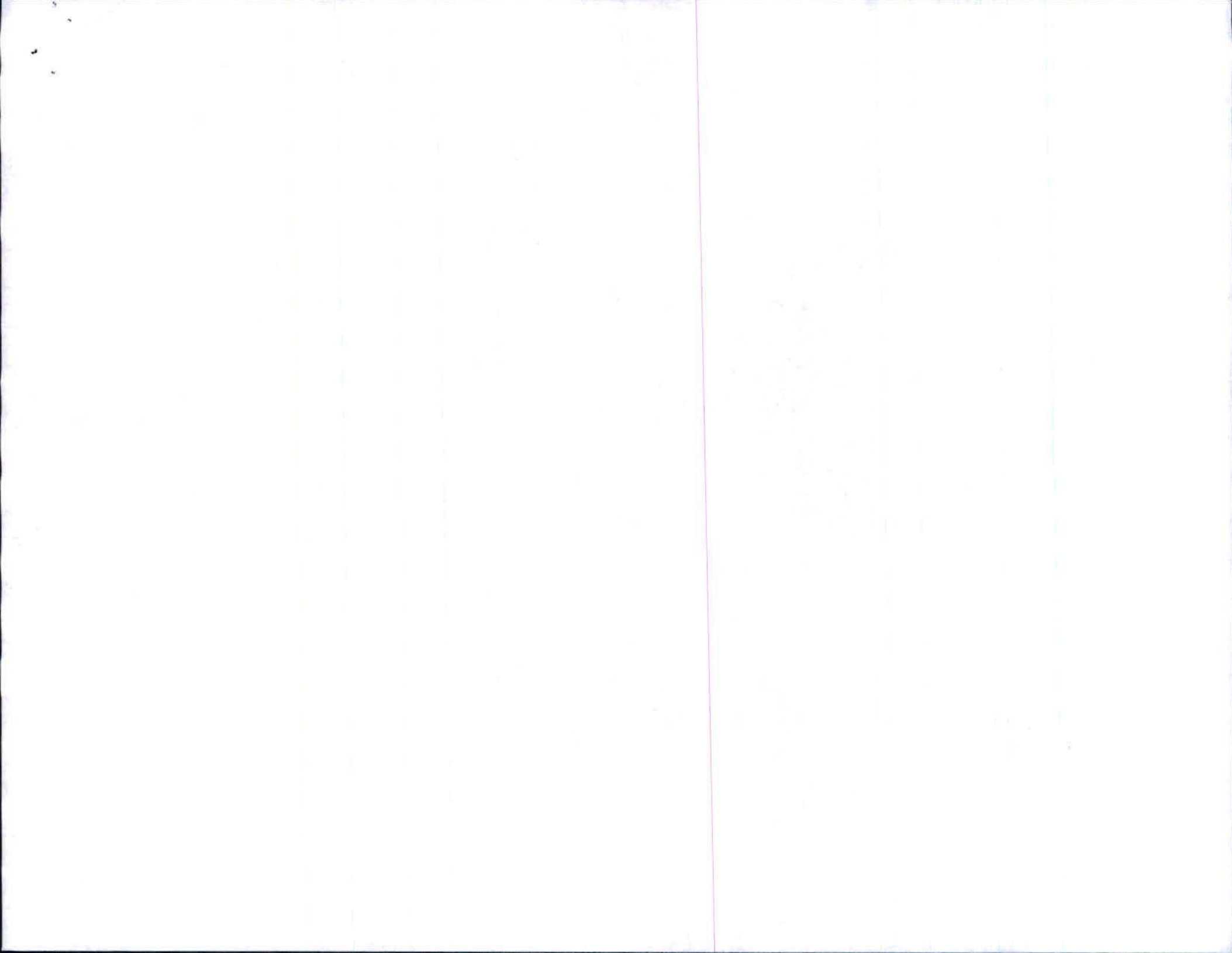
Comment: FINAL INSPECTION/W/O RELEASE

07/05/23

Job Completion



07-05-23



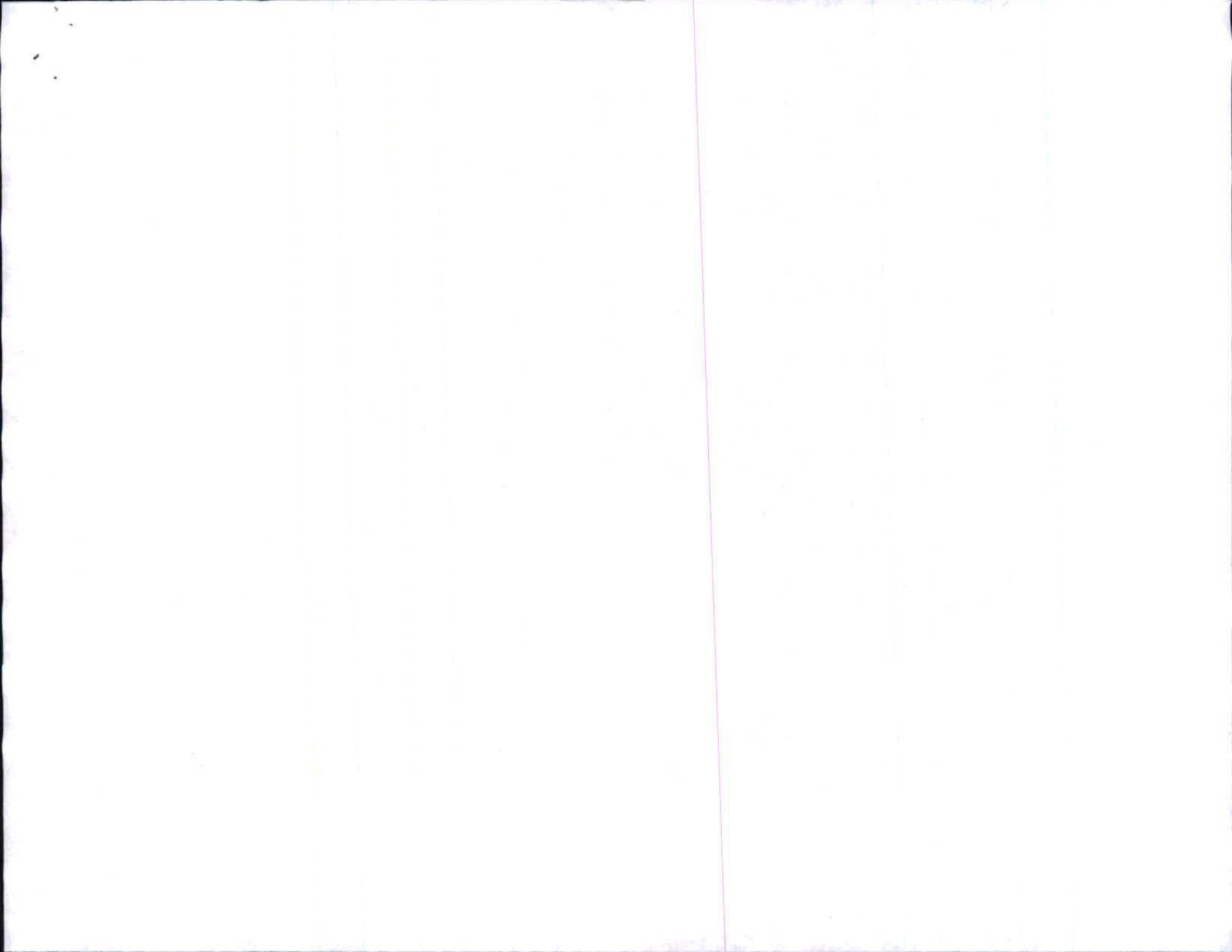


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0705-16	10.0	original was split for a qty of 8 on the B31870-1, and Qty 5 to remain on this w/o	J	0705-16	5	J 0705-16	J 0705-16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/05/23  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

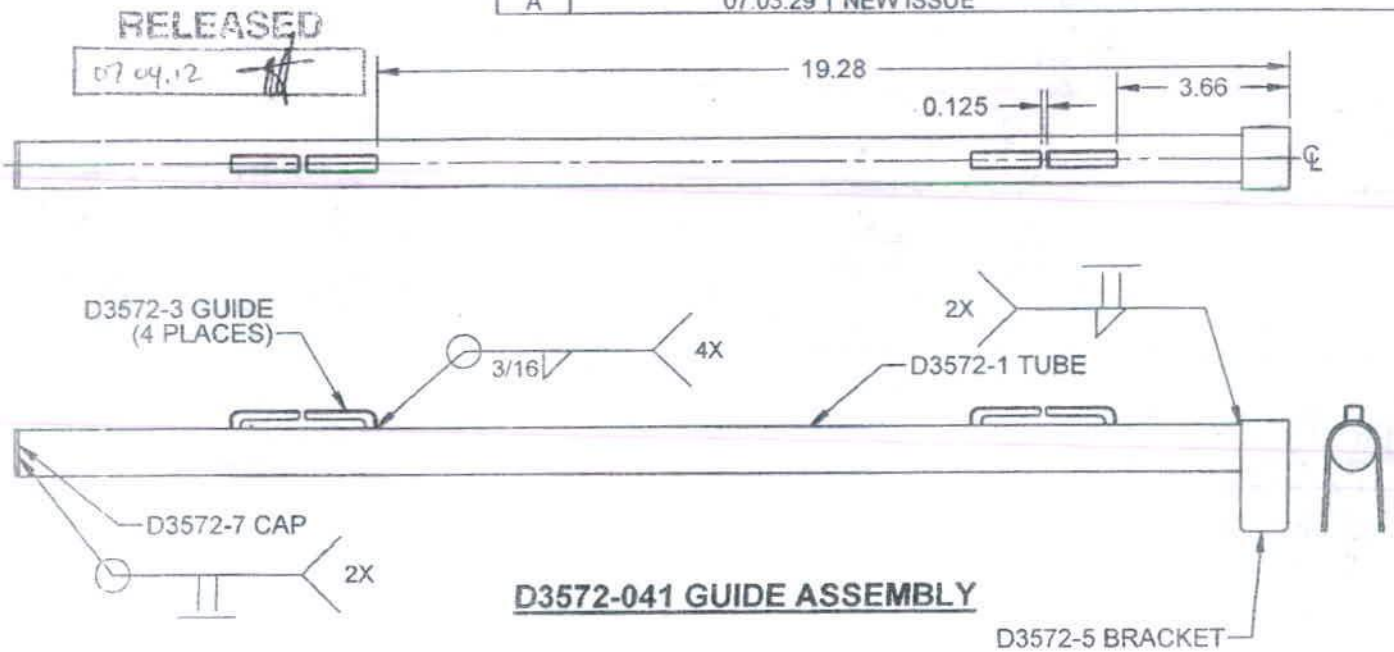
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-15	5.0	Brake disc face between Hla D3572-3 Gouges Jaws from 0.140" → 0.160". 3 parts.	J 0705-22	Scrap: destroy  Qty 2 good remain.	JB 0705-22	J 0705-22	J 0705-22	J 0705-22
0705-15	5.0	1 X D3572-1 tube material was missing. No more left in stock.	J 0705-22	Replace/subst. tube using, 1" od 6061-T6 Solid Rod. → REQUIRED EXTRA HEATING AND WELD MATERIAL	See original	J 0705-22	J 0705-22	J 0705-22
0705-15	5.0	1 part too k. Used for testing, with solid bar.	J 0705-15	test & scrap, no replace.	LG 0705-15	J 0705-15	J 0705-15	J 0705-15

NOTE: Date & initial all entries

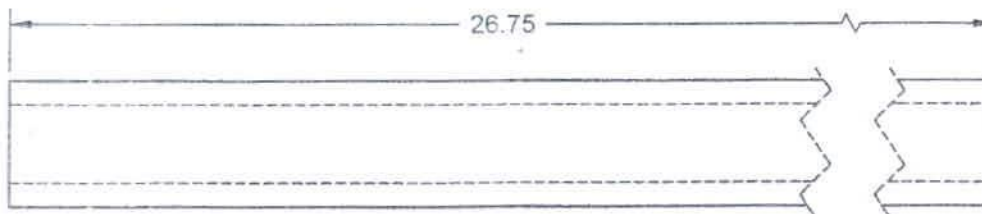


**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3572	REV. A SHEET 1 OF 2
DATE 07.03.29	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE	

**D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

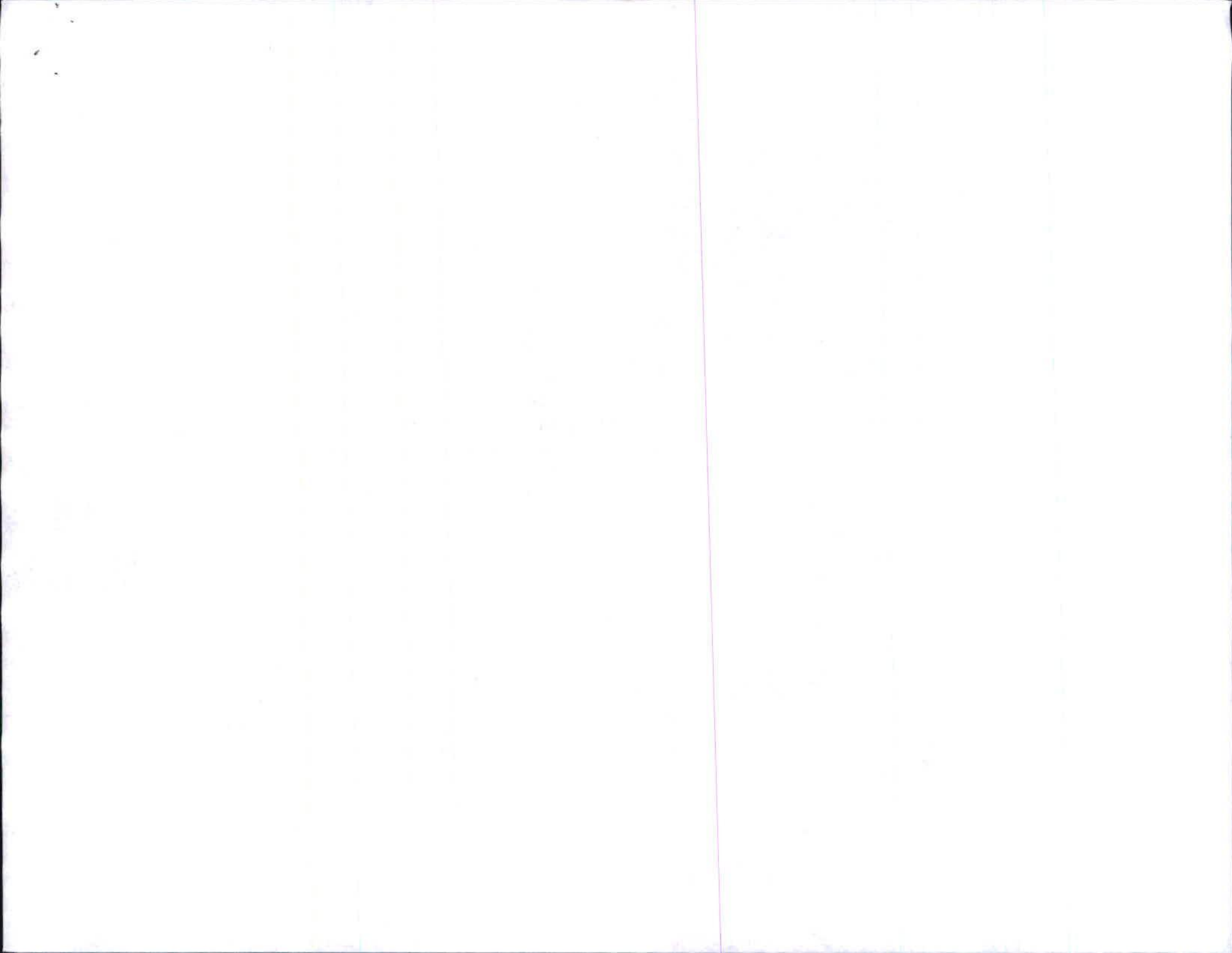
**D3572-1 TUBE****D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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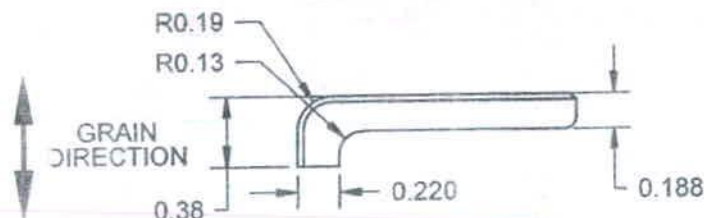
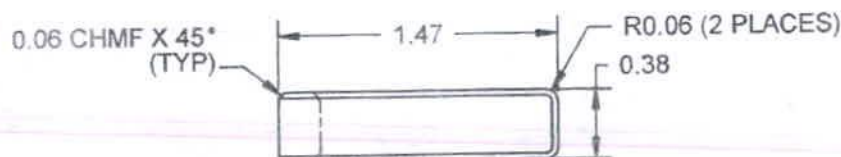
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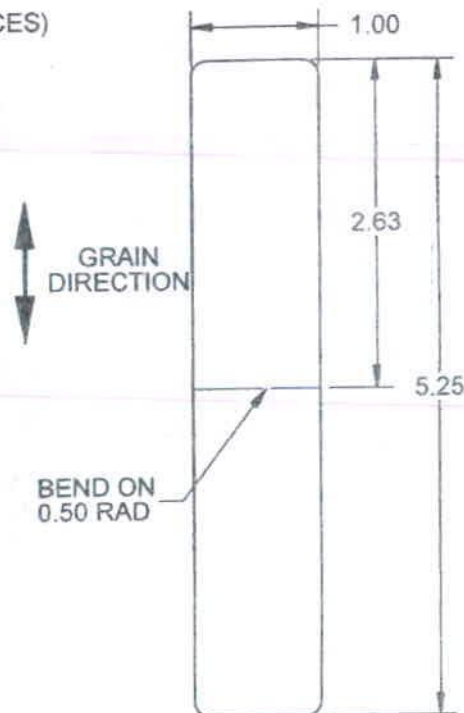
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.29		TITLE GUIDE ASSEMBLY	SCALE 2:3



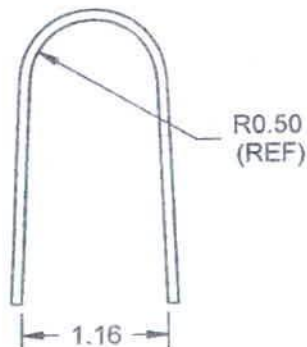
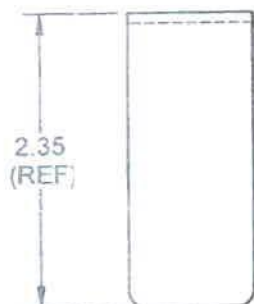
1 **D3572-3 GUIDE**

RELEASED

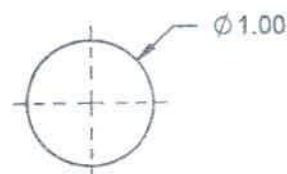
07.04.12 *[Signature]*



2 **D3572-5F FLAT PATTERN**



**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



2 **D3572-7 CAP**

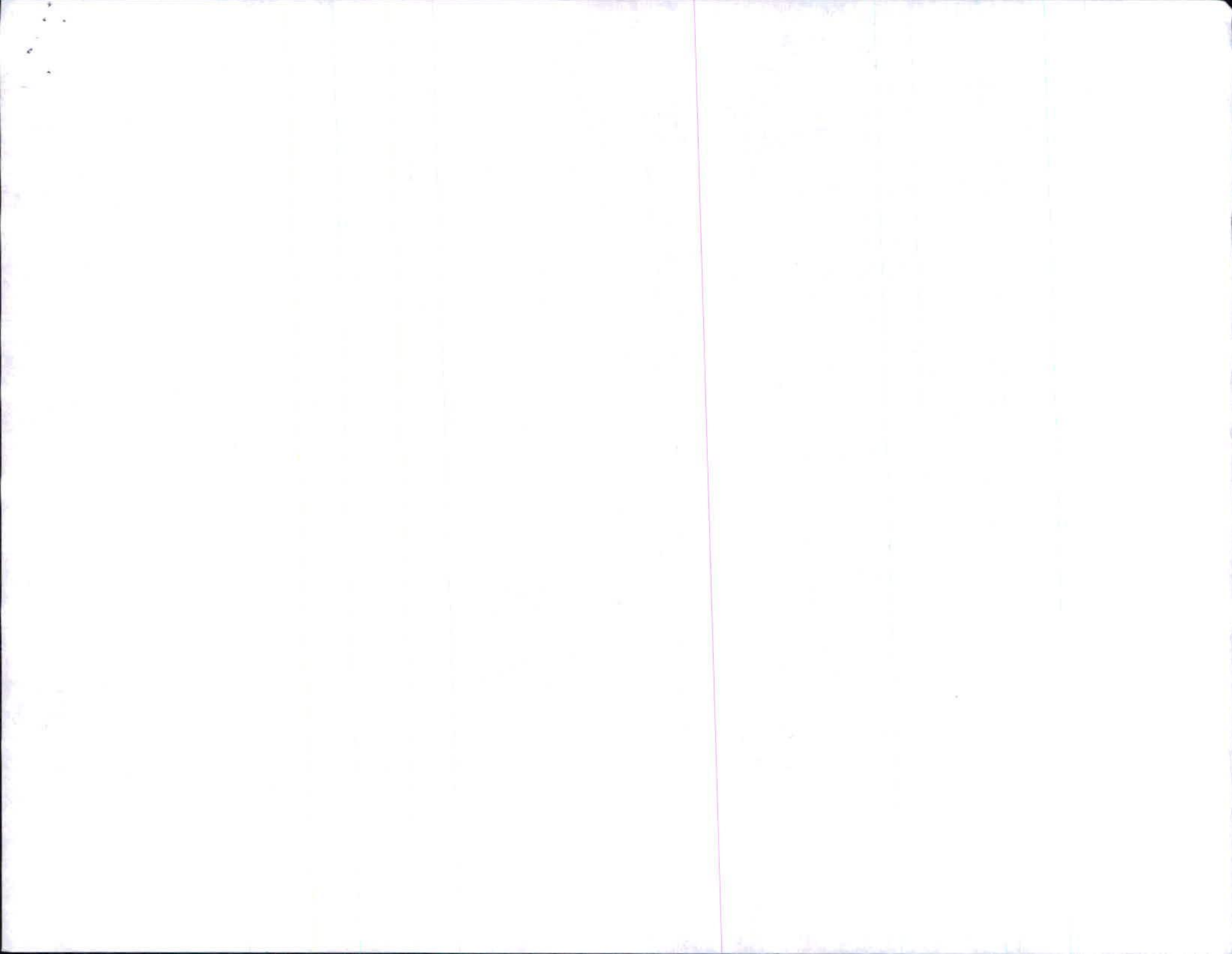
**D3572-3/-5/-7 NOTES:**

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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31870



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

